

Work Order ID 86049-1

June-19-12 4:13:00 PM

Split - 1

86049

Page 1

Item ID: D2573

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Aft Out 205

Start Date: 19/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 09/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 12/06/19

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

PO/B. 12/07/01

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No 86049 Double check by: B. 1-Machine Step
No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine
Step No 2 per Folio FA051 and inspect per attached Dimension Sheets3-
Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

12/07/10

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

PO/B. 12/07/01

QC

Memo

0.00

Quality Control

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

1000

Work Order ID 86049

June-19-12 4:13:00 PM

86049

Page 2

Item ID: D2573

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop *NS2*

Start Date: 19/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 09/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00 Smb 12-7-18

12-07-18

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

1200

11:30

11x ϕ 12/6/23 M-L

11x ϕ 12/6/23 M-L

1121841

Work Order ID 86049

June-19-12 4:13:00 PM

86049

Page 3

Item ID: D2573

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Aft Out 205

Stop *NS2*

Start Date: 19/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 09/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

11 *φ* *BL 0723.*

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

58433

12/1/23 @

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/24

mf
12-07-23

Picklist Print

June-19-12 4:13:03 PM

Page 1

Work Order ID: 86049

86049

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 19/06/2012

Required Date: 09/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: I As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	47.0000	1	12			
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D6101-007

Saddle Billet

**

SL 12-06-28

Location

Loc Qty

Loc Code

MAT041

46

83450

16

85432

30

MAT042

1

79875

1

12

المجلد الثاني

DART AEROSPACE LTD		Work Order: 86049
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.009	8.001	8.001		
F	0.490	0.510		0.495	.504	.495	.495		
G	0.257	0.262		0.258	.258	.258	.258		
H	0.375	0.380		0.376	.377	.377	.377		
I	0.490	0.510		0.500	.499	.496	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.566	.564	.561	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.128	.125	.125	.126		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.251	.251	.251	.251		
S	0.115	0.135		0.124	.120	.121	.120		
T	0.178	0.198		0.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.240	.236	.238	.238		
W	0.115	0.135		0.122	.122	.125	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.363	.362	.363	.363		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.607	.620	.625	.625		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.247	.244	.246	.245		
AE	1.500	1.520		1.514	1.518	1.512	1.517		
AF	0.115	0.135		0.120	.120	.120	.120		
AG	0.240	0.280		0.275	.275	.275	.275		
AH	0.240	0.260		0.247	.245	.248	.247		
AI	2.000	2.020		2.000	2.008	2.002	2.007		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: PO / B.A.
Date: 12/07/01

Audited by: smB / JL
Date: 12/07/18 / 12-07-18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	06049
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				A5	A6	A7	A8		
A	0.438	0.443		.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.002	8.000	8.003		
F	0.490	0.510		.510	.498	.501	.504		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.566	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.125	.125	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.126	.130	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.367	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.249	.256	.256		
AE	1.500	1.520		1.514	1.514	1.514	1.516		
AF	0.115	0.135		.120	.120	.120	.120		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.249	.249	.250	.250		
AI	2.000	2.020		2.004	2.004	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	12-07-04

Audited by	Smis
Date:	12.7.18 / 12.07.18

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	02.09.26	Re-format; Added Rev. D	RF	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ	
E	05.12.05	Added dimension AJ	KJ/RF	
			KJ/JLM	

DART AEROSPACE LTD	Work Order:	86049
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				ϕ_9	ϕ_{10}	ϕ_{11}	ϕ_{12}		
A	0.438	0.443		.439	.439	.479	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.236	.237	.237	.236		
W	0.115	0.135		.123	.122	.122	.123		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.623	.624	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.245	.245	.245		
AE	1.500	1.520		1.513	1.513	1.513	1.512		
AF	0.115	0.135		.120	.120	.120	.120		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.245	.248	.246	.247		
AI	2.000	2.020		2.004	2.003	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 12/07/23	Date: 12-04-23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DATE RECEIVED

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05.12.06 $\frac{1}{2}$

WORK ORDER
NO. 86049 MLJ
12/06/19

